



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4931-3

Job Sheet 168430



Part No: D4931-3

Job Qty: 3 ea

Part Name: Engine Fitting (For B3 Models)



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/14/17

Job Tracking No:

Due Date: 12/6/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A SHEET 2 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		12/5/17	0.00	0.00	Start Up Machining		
100	Doosan	3 pcs		12/5/17	0.52	2.97	Doosan		
110	QC	3 pcs		12/5/17	0.00	0.00	QC2		
112	Mill Conv	3 pcs		12/6/17	0.00	1.15	Mill Conv 1		J.C.L. 17-12-06
115	QC	3 pcs		12/6/17	0.00	0.00	QC2		J.C.L. 17-12-06
120	QC	3 pcs		12/6/17	0.00	0.00	QC8		J.C.L. 17-12-06
130	Packaging	3 pcs		12/6/17	0.00	0.00	Packaging3	5/12/7	AT
140	QC21-SA	3 Ea		12/6/17	0.00	0.00	QC21		

Part Op 100 - Machine as per folio FB210
Descriptions: 112 - DRILL HOLES AS PER REQUIRED

DEC 07 2017

Job Allocations

Op
90-

DART
AEROSPACE
S017077

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td Qty

f.leroux,jason



Engine Fitting (For B3 Models)

PART NO: D4931-3

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/04/17

Job No: 168430

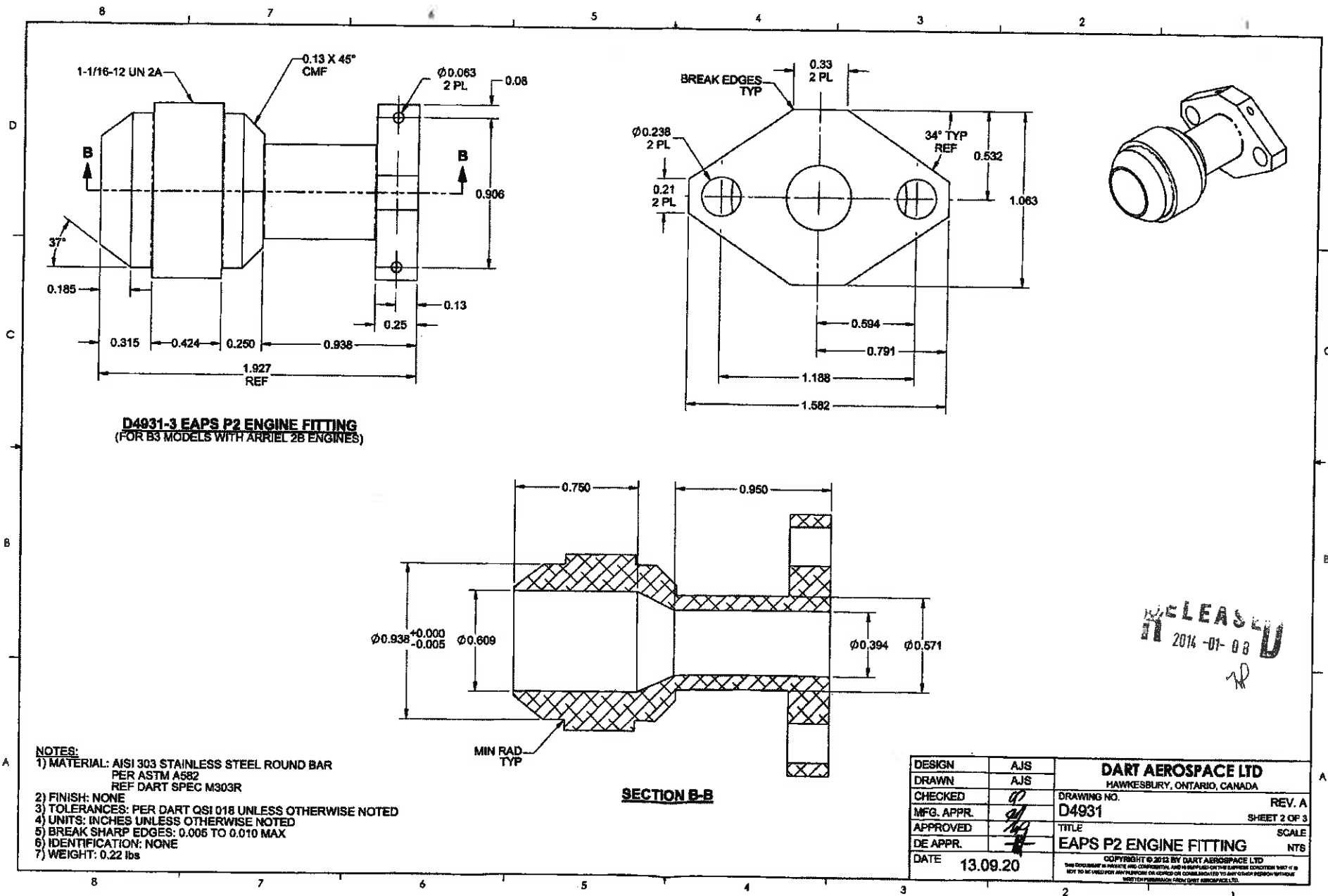
DART AEROSPACE LTD		Work Order: 168 430
Description: EAPS P2 Engine Fitting		Part Number: D4931-3
Inspection Dwg: D4931	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	Maj: 1.0608 Min: 1.0494	1.055	✓		MIC LPO2	
M.O.W.	Maj: 1.0995 Min: 1.0938	1.097	✓		↓	
0.13 x 45°	+/-0.030 x +/-0.5°	130.515°	✓		Protractor	
Ø0.063	+0.004/-0.001	.064	✓		gauge pin	
0.08	+/-0.030	.078	✓		Height gauge	
0.906	+/-0.010	.908	✓		↓	
0.13	+/-0.030	.130	✓		Vern LPO8	
0.25	+/-0.030	.255	✓		↓	
0.938	+/-0.010	.943	✓		↓	
1.927	+/-0.010	1.932	✓		↓	
0.250	+/-0.010	.245	✓		↓	
0.424	+/-0.010	.426	✓		↓	
0.315	+/-0.010	.308	✓		↓	
0.185	+/-0.010	.180	✓		↓	
37°	+/-0.5°	37°	✓		Protractor	
0.33	+/-0.030	.340	✓		Vern LPO8	
34°	+/-0.5°	34°	✓		Protractor	
0.532	+/-0.010	.532	✓		Vern LPO8	
1.063	+/-0.010	1.065	✓		↓	
0.594	+/-0.010	.594	✓		Caliper JCL-08	
0.791	+/-0.010	.787	✓		Vern LPO8	
1.188	+/-0.010	1.188	✓		Caliper JCL-08	
1.582	+/-0.010	1.586	✓		Vern LPO8	

Measured by: 17-12-04 JCL	Audited by: JL	Preliminary Approval:
Date: 17-12-06	Date: 17-12-7	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	



RELEASED
2014-01-08
U

DQA:

28

Date:

Oct 30/19

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACE

QA Closed:

Date:

Work Order update only ☐

Work Order: <u>168430</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>104931-3</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>19-7647</u>		Scrap ☒		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>17-12-06</u>		Step #: <u>112</u>		QTY Effective: <u>2</u> <u>11</u>				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
The drill broke while drilling and damage the part.				Scrap / noneplex destroy				 <u>J.C. V.</u> 17-12-06	
								Lead hand / Supervisor Approval Verification	
								 <u>J.C. V.</u> DEC 07 2017	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☒	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☒	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								